

Work Order ID 74955

Thursday, October 13, 2011 1:02:54 PM

74955

Soon

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Item ID: D4055-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tank Fwd End
 Start Date: 10/13/2011 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 10/20/2011 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: mf Date: 11-10-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4055	B								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per dwg D4055								
	Prog rev: <u>B</u>								
	Dwg rev: <u>B</u>								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

B11-10-14
DEBUR B11-10-28

(4)

B11-10-14

Sulko

(74)

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Item ID: D4055-7

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tank Fwd End

Start Date: 10/13/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 10/20/2011 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

Bend 18 - 20 degrees

140

QC6- Inspect dimensions to drawing

0.00

140

QC

Memo

0.00

Quality Control

141

Chemical Conversion Coat per QSI005 4.1

0.00

141

HandFinish

Memo

0.00

Hand Finishing

4XDM 11/11/10

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
142	QC3- Inspect Part Finish	0.00							
142									
QC	Memo	0.00				4	0	11/11/10	
Quality Control						COUNTED			
150	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
150									
Packaging	Memo	0.00				4	0		
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

11/11/15
 ME
 11-11-14

Picklist Print

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Work Order ID: 74955

Parent Item: D4055-7

Parent Item Name: Tank Fwd End

Start Date: 10/13/2011

Required Date: 10/20/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM
house DD verf:EC

IPP rev:B 10.11.23 now made in

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4055-7P Tank Fwd End		Purchased	No				Each	0.0000		5			
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	126.8856	3.12	16.421053	13		

811-10-14

Location

Loc Qty

Loc Code

MAT021

126.8855684

116308

26.9755684

117285

88.91

118580

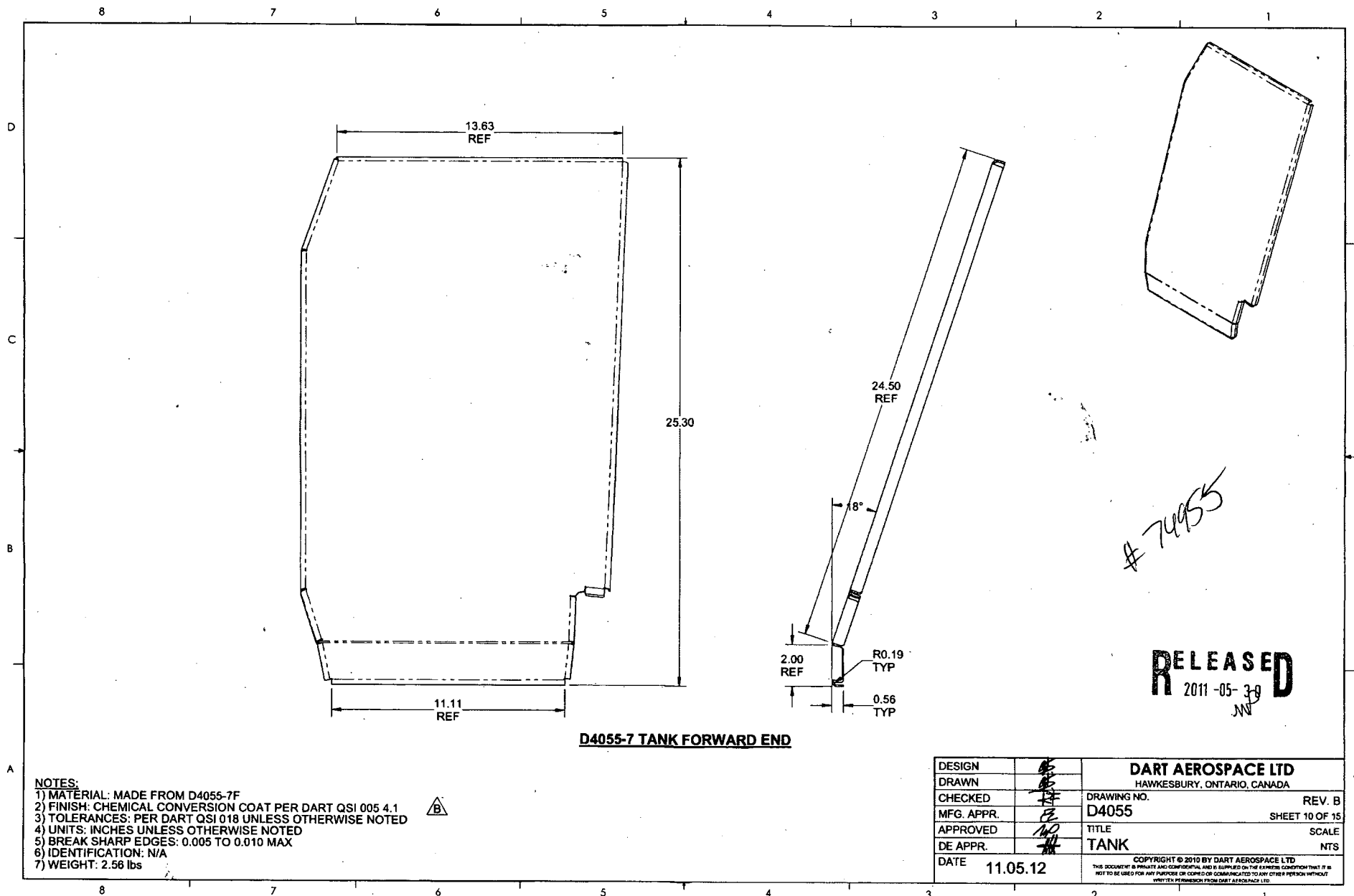
11

118580

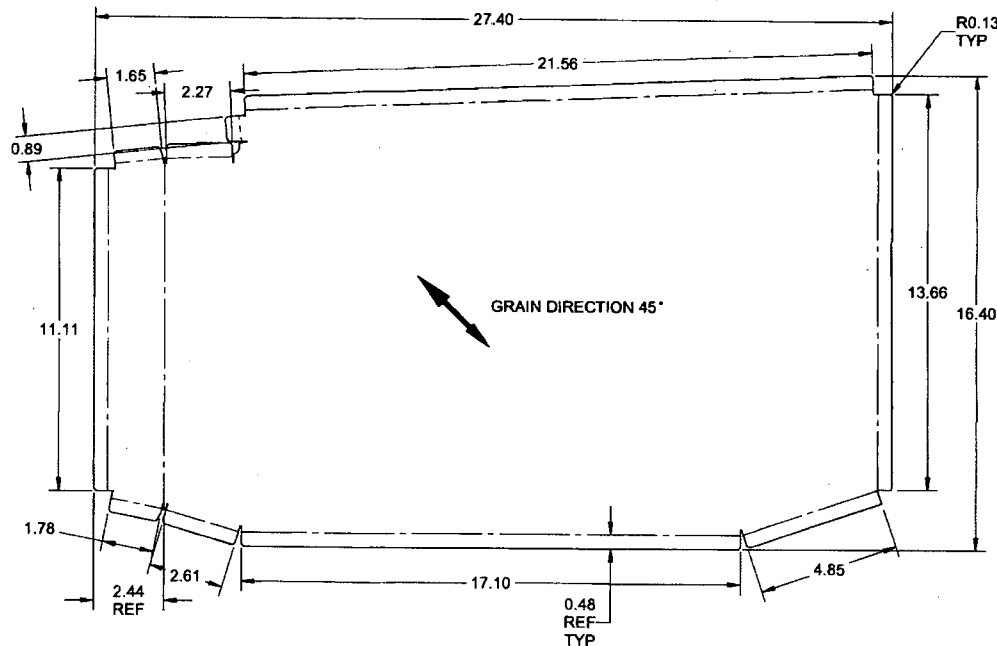
(4)

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	11.01.18	New Issue	KJ	
B	11.06.21	Dimensions updated per Dwg Rev B	KJ	



0.063
REF



D4055-7F FLAT PATTERN

RELEASED
2011-05-30
JW

NOTES:

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063

2) FINISH: N/A







3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 2.56 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 11 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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